Date: Wednesday, 04/06/2008 12:36:38 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM (S-76)	
Job Number	: 39695			
Estimate Number	: 11894			
P.O. Number	:	Part Number	: D2262	
This Issue	: 04/06/2008 S.O. No. :	Drawing Number	: D2262 REV A1	
Prsht Rev.	: NC	Project Number	: N/A	
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A1	
Previous Run	: 33330	Material	:	
Written By	:	Due Date	: 11/06/2008 Qty: 10 Um: Each	
Checked & Approved By	: _JW 08.6.04_			
Comment	: Est : D 02.04.15 Added dwg Rev.A1 NG			

Additional Product

Job Number: |||||||||||||

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.:   1.0948 f(s)/Unit   Total :   10.9484 f(s)
Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall
(M304TR0500W035)   Batch No: _M 108 215_

Seq. #:	Machine Or Operation:	Description :
2.0	BRAKE NC	NC BRAKE

Comment: BRAKE NC
Punch tube 304/316 with 2B finish
Deburr   _CB 08/06/10_   _SB 08/06/04_   (10)

Seq. #:	Machine Or Operation:	Description :
3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   _08/06/10_   (x 10)

Seq. #:	Machine Or Operation:	Description :
4.0	POWDER COATING	POWDER COATING

_M 102316_   (10x)

Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _9:20_
OVEN TEMPERATURE: _320 °F_
FINISH TIME: _9:50_   _m.l_   _08/06/10_

Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT   _08/06/10_   (10)

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WORK ORDER CHANGES

W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services   **Drawing Name:** MIRROR ARM (S-76)

Job Number: 39695   **Part Number:** D2262

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2022101	Spacer

Comment: Qty.:   2.0000 Each(s)/Unit   Total :   20.0000 Each(s)
Spacer
Pick:

Qty	Part Number	Description	Batch
4	D2022-101	Spacer	B33985

AS 08/06/10 (XL)

7.0	A1449	Grommet

Comment: Qty.:   1.0000 Each(s)/Unit   Total :   10.0000 Each(s)
Grommet
Pick:

Qty	Part Number	Description	Batch
2	A1449	Grommet	M1487

AS 08/06/10 (XL)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2262

FF 08-06-12   (10)

9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (XL)

10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST262228

AS 08/06/12 (XL)

11.0	QC21	FINAL INSPECTION/W/O RELEASE

08/06/12

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-06-12

Job Completion

Form: rprocess

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No   DQA: _____   Date: _____
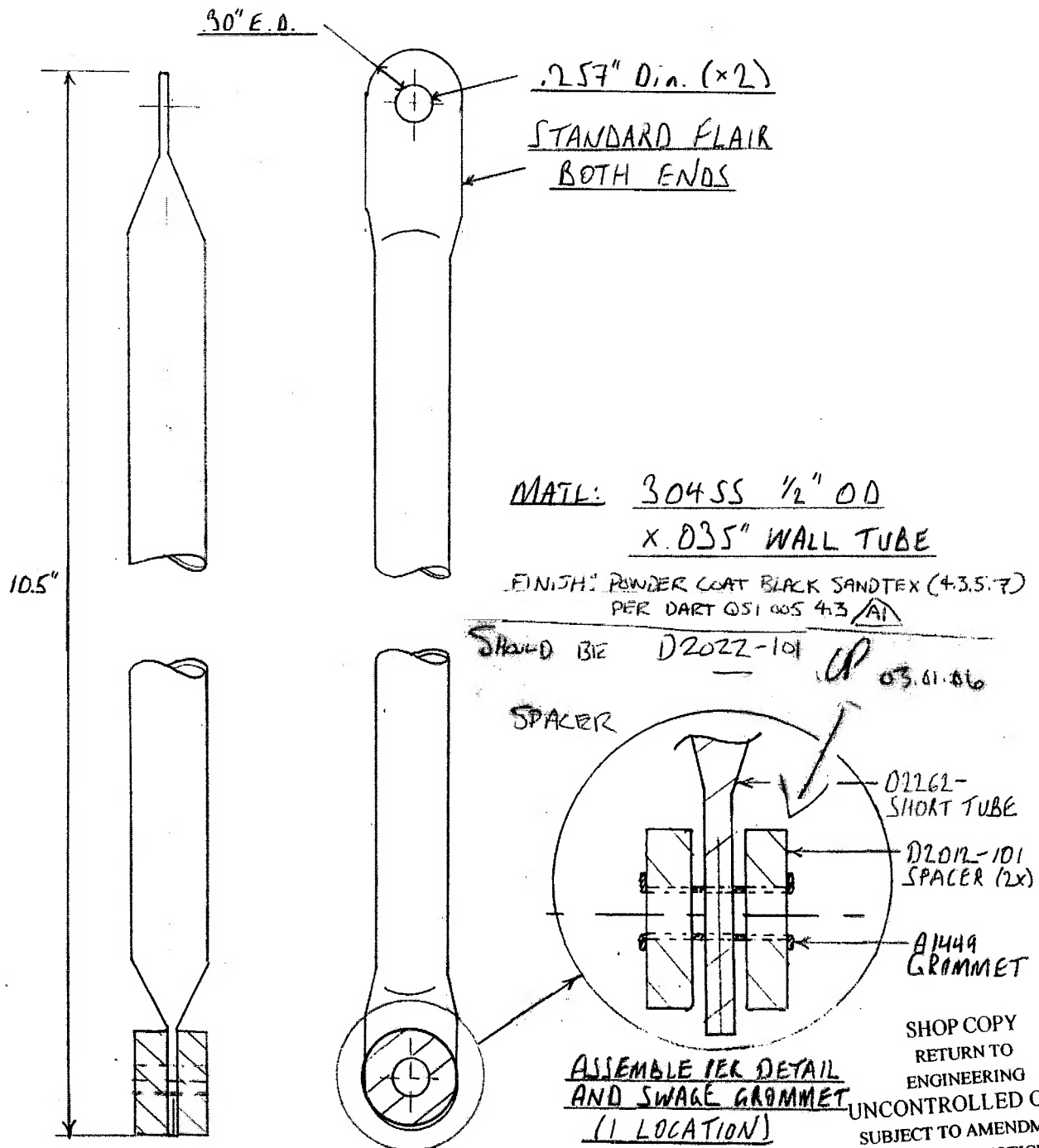
QA: N/C Closed: _____   Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action — Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DRAWN M. Cohen	**DART AERO ACCESSORIES INC** VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN	DRAWING NO. D2262	REV. A
		SHEET 1 OF 1
Aug 10/94	TITLE SHORT TUBE	

A1	CP	02.03.22	ADD FINISH

.90" E.D.

.257" Dia. (×2)

STANDARD FLAIR BOTH ENDS

10.5"

MATL: 304 SS ½" OD X .035" WALL TUBE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 /A1\

SHOULD BE D2022-101

SPACER

CP 03.01.06

D2262- SHORT TUBE

D2012-101 SPACER (2x)

A1449 GROMMET

ASSEMBLE PER DETAIL AND SWAGE GROMMET (1 LOCATION)

WORK ORDER NO. 3409S

Dart Aerospace Ltd

W/O:		**WORK ORDER CHANGES**						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No   DQA: _____ Date: _____

QA: N/C Closed: _____   Date: _____

NCR:		**WORK ORDER NON-CONFORMANCE (NCR)**						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries